Work Orde September-23-1.				*107:	392*							Page 1
Item ID: Revision ID:	D4006-041	pport Assembly	A	Accept	*N900	040	100)*	Setup	Start Stop	I	S1* S2*
Start Date: Required Date: Reference:	9/23/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	Process Pl	lan: MLJ	Date: 13-09-24	Tooling:	Da	ite:	_		Run	Start	*N	R1*
			Date:	SPC (Y/N):	Da	ite:				Stop	*N	R2*
Sequence ID/ Work Center II	Ď	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	t Re	-	Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr										
D4006	B	!									, , , , , , , , , , , , , , , , , , , ,	1
100				0.00								//
100 Small Fab		Memo Assemble a	s per dwg D4006	0.00				_/X_				73
			, ,	DAS 27							,	
110		QC5- Inspect part comp	oleteness to step on W/O	0.00 9-89 13 9 2	S			1				
110 QC Quality Control		Memo		0.00	O							
120		Gloss Grey (4.3.5.15) p	er QSI 005 4.3	0.00				1. 1	_		/	
120 Powdercoat Powder Coating	17	Memo Start Time Oven Tem Finish Tim	perature:) (200			•	ΙΧJ		M-	Vl.	3/04/
11185	,50		9:15									

												DQA:	D	ate:	
NCR: Y	es/	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UP	DATE					
												QA Closed:	D	ate:	
Work Orde	or.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Work Orde	-'' -					Rework	1		Skid-tube	Crosstube]	Water Je	t∏	Engineering
Part N	۱o.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor		Quality
						Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging	g	Other
NCR N	۱o.					Work Order Update			Large Fab	Composite]	Supplie	r	
Root			·		Descri	ption of work order update	Π	Initial	Ac	ction		Sign &			
Cause		Date	Step	Qty	1	or Non-conformance		ief Eng		cription		Date	Verification	on	QC Inspector
Doc/Data										-				-	
Equip/Tooling															
Operator														į	
Material															
Setup					1										
Other	Ш						l							!	
Process			Ì											1	
Supplier			ļ											1	
Training															
Unapproved							L.								
						F	AUI	T CATE	GORY						
Landi	ng (Gear				General	_	_				_			
		Bending			ļ	Bend		Grain				Ovalized			Pressure/Forced
	Centre Not Concentric to O/S BOM/Route						\perp	Hardwa	re			Over/Under	tolerance	L	Temperature/Cure
	Cracks Broken/					Broken/Damaged	L	Inspect	ion Incomplete			Part Incorre	ct		Weld
	Crushed/Crimped Burrs					Burrs	L	Instruct	ions Incomplete,	/Unclear		Part Lost/M	ssing		Wrong Stock Pulled
i .	Cuffs Contamination					Contamination		Mainte	enance			Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde September-23-13				*1	07	392*							Page 2
Revision ID:	D4006-041 Tank Top Sup	port Assembly	,	Accept		*N900) 040	100	*	Setup	Start Stop	*N:	S1* S2*
	9/23/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*			Cust Item Customer							. 17
Approvals:	Process Pla	on:	Date:	Tooling: SPC (Y/N): -		Date:		j		Start Stop		R1* R2*
Sequence ID/ Work Center II 130 *130*)	Operation Description QC3- Inspect Part Finish		Set Up Run H		Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
QC Quality Control		Memo		0.00						- (#			
140 *1 4 0*				0.00					K				13/10/20
HandFinish Hand Finishing		3M 1300L Ba	and install Foam as per datch: 124397 nor nuts as per dwg	0.00 wg					_/~~	-			
150 *150*		QC5- Inspect part comple		0.00	DAS 27 9-89	•			i				
QC		Memo		0.00	3 10.	24							

Quality Control

	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE									Date: _	£ • •
NCR: Yes	/ No				WORK ORDER NON-C	ONFORI	MANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier				ť				,			

Landing G	Bear	General			 _
	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		-
	Wave/Twist in Tube	Folio	Outside Dimensions		

FAULT CATEGORY

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Training Unapproved

Work Ore September-23				*107	7392*						Page
Item ID: Revision ID:	D4006-041	l ·		Accept	*N900	040	100)* s	etup Star	t *N	S1*
Item Name:	Tank Top S	upport Assembly							Stop	' *N	S2*
Start Date:	9/23/13	Start Qty: 1.00	*1*		Cust Item I	D:					
Required Date	e: 9/23/13	Req'd Qty: 1.00	*1*		Customer:						
Reference:			_								
Approvals:	Process F	Plan:	Date:	Tooling:	Da	ate:		R	un Star	1/1	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	" *N	R2*
Sequence ID/ Operation Work Center ID Description				Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*160		Identify as per dwg & St	tock Location:	134.00				DAS 32	13/	129	(i)

170

QC21- Final Inspection - Work Order Release

0.00

0.00

170

Packaging

Packaging

Quality Control

Memo

Memo

0.00

1 Rm 13/10/29 MK 13-10-29

Page 3

				DQA:_	Date: _	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	No.			···		Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root			ļ		Descri	ption of work order update	Ti	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator													
Material]											
Setup	<u> </u>		1										
Other		1											
Process	_]											
Supplier		1	1			,		>					
Training	_	1											
Unapproved				<u> </u>			<u> </u>					<u> </u>	
						· · · · · · · · · · · · · · · · · · ·	AUL	T CATE	GORY				
Landi	ng (Gear .			_	General		l		_	1		7
	⊢	Bending	_			Bend	<u> </u>	Grain		<u> </u>	Ovalized		Pressure/Forced
	┡	Centre N	ot Conce	ntric to C	^{D/S} -	BOM/Route	_	Hardwa		ļ	Over/Under		Temperature/Cure
	<u> </u>	Cracks			<u> </u>	Broken/Damaged	-		ion Incomplete		Part Incorre		Weld
	<u> </u>	Crushed/			Burrs	<u> </u>	1	ions Incomplete/		Part Lost/Mi	issing	Wrong Stock Pulled	
	Cuffs Contamination							Mainte			Part Moved		
	Heat Treat Countersink Inspection Strip in Tube Cut Too Short							Mislabe		⊢	Positioned V		7
	-	4 '	•	Tube	-	Cut Too Short	-	Misread	d		Power Loss/	Surge	Other
		Ripples in			\vdash	Drill Holes	<u> </u>	Offset			· · ·		
	_	Torque V			·	Drawing		1	Calibration				
		- 1 - 1	Sequence		L	Finish	—	ł	Sequence				
1	1	IWave/Tv	vist in Tul	he	1	IFolio	1	I∩utcide	Dimensions				

September-23-13 11:49:52 AM

Work Order ID:

107392

Parent Item:

D4006-041

Parent Item Name:

Tank Top Support Assembly

Start Date: 9/23/13

Required Date: 9/23/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP rev A 09.12.18 new issie Prelim EC verified by:DD

562 DD verified by:EC

IPP Rev:C 10.07.12 added type of glue DD verf:JLM

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
)4006-1 Angle		Manufactured	No			100	Each	8.0000	1	1		3/09	be
				Location		Loc Oty	Lo	oc Code				/ /	,
				GA		8							
				10	0362	8		• • • • • • • • • • • • • • • • • • • •		-	0.	. ,	/ /
D4006-3 Channel		Manufactured	No			100	Each	2.0000	2	2	5	3/0	8/20
				Location		Loc Qty	<u>L</u> c	oc Code				,	
	_			ST083		2				<u></u>			
	DAS			10	0437	2				4		/	
D4006-5 Foam <i>3</i>	98 ⁹ 96 999	Manufactured	No			140	B/0	7.39	3(7)	1	13	/10 /	25
D4006-5 Foam MS20426AD3-4	A	Purchased	No			140	Each	15,330.000	4	4	[3]	10/2	0
1710	ſ '			Location		Loc Qty	<u>L</u> e	oc Code			/		7 c
·				ST334		73							£,
				12	3164	73							
				ST505		7137					_		- 7
					4374	12					MI	a 33	50
					3021	12					1.		
					4814	7113						([]n	())
				ST509	A507	8120						7	> /
					4586 5578	120 8000							

IPP Rev:B 10.05.03 as per ECN10-

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	OA Classel	Data	
						T	1				QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part	-					Rework Scrap Use-as-is		. 1	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR	No.				<u></u>	Work Order Update]		Large Fab	Composite	Recystor	Supplier	
Root	Ĭ				Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause	l	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		* -											
Equip/Tooling							İ						
Operator													
Material													
Setup													
Other			1										
Process							1						
Supplier													
Training													
Unapproved							İ						
						F	AUI	T CATE	GORY				
Land	ing (Gear				General							
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
Crushed/Crimped Bu						Burrs		4	ions incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
						Contamination		Mainte	•		Part Moved		_ ~
						Countersink		Mislabe			Positioned V	Vrong	
		Inspectio		Tube		Cut Too Short		Misread			Power Loss/		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-23-13 11:49:52 AM

Work Order ID:	107392							
Parent Item:	D4006-041					Start 1	Date: 9/23/13	Required Date: 9/23/13
Parent Item Name:	Tank Top Support Assembly					Start	Qty: 1.00	Required Qty: 1.00
MS20470AD4-5 RIVET, UNIVERSAL H	Purchased EAD	No		100	Each	3,189.0000	8	8 3/09/26
	•		Location	Loc Qty		Loc Code		
			ST336	3189				_
			125654	189				<u> </u>
			m126926	3000			8_	- , /
MS21059L4	Purchased	No		140	Each	76.0000	2	2 /3 /10 /29 DAS 36
Nutplate								3/10/29 DAS 36
			Location	Loc Qty		Loc Code		\$89 \$89
			GA	55				· —
			125535	55				_
			ST316	21				_

15

122441 123900

				DQA:	Date:							
NCR: Ye	s / No				WORK ORDER NON-	CONF	ORN	MANCE / UP	DATE			
										QA Closed:	Date:	
Work Order	·•				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Order	•				Rework	7		Skid-tube	Crosstube	7	Water Jet	Engineering
Part No	o				Scrap		ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is] T		noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No	o				Work Order Update]		Large Fab	Composite	<u> </u>	Supplier	
Root				Descri	ption of work order update	Init	ial	Ac	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief	Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data					,							
Equip/Tooling	_	1		Ì							İ	
Operator	_											
Material	_											
Setup	_											
Other	_											
Process	_									,		
Supplier	4											
Training	4											
Unapproved			1	<u> </u>	f	AULT C	ATE	GODA				
l and!a						AULIC	. MIE	GUNT				
Landing	g Gear				General	Пс	rain		·	Ovalized		Pressure/Forced

Hardware

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Over/Under tolerance

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Temperature/Cure

Wrong Stock Pulled

Weld

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

BOM/Route

Contamination

Countersink

Cut Too Short Drill Holes

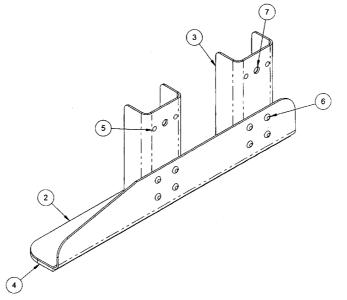
Drawing

Finish Folio

Burrs

Broken/Damaged

ITEM NO. QTY.		PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER		
1	X	D4006-041	TANK TOP SUPPORT ASSEMBLY	JCA-M47-2-01		
2	1	D4006-1	ANGLE			
3	2	D4006-3	CHANNEL			
4	1	D4006-5	FOAM			
5	4	MS20426AD3(-4)	RIVET			
6	8	MS20470AD4(-5)	RIVET			
7	2	MS21059-4	ANCHOR NUT			



107392 MLJ 13-09-24

D4006-041 TANK TOP SUPPORT ASSEMBLY

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 7) WEIGHT: 0.48 lbs
7) WEIGHT: 0.48 IDS

8	"ANSI 6	NGE POWDER COAT FROM "GREY SANDTEX" TO DC 12.02.2				
A	NEW IS	SUE		1	10.02.05	
REV.			BY	DATE		
DESIGN DRAWN		8	DART AEROSPACE LTD			
		DC	HAWKESBURY, ONTA			
CHECKED MFG. APPR.		8 5	DRAWING NO.		REV. B	
		B	D4006		SHEET 1 OF 6	
APPROVED DE APPR.		143	TITLE		SCALE	
		-#	UPPER RESTRAINT		NTS	
DATE	12.0	2.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD his collect a provide and consorting and a supple on the popels condition that it is not to be used for any purpose or confet or collaboration to their pression without			

3

7

6

5